

23. (New). The system, as set forth in claim 18, wherein a third set of blocks are displayed in a third color.

24. (New). The system, as set forth in claim 23, wherein the third set of blocks are dependent upon the active block.

25. (New). The system, as set forth in claim 23, wherein the third set of blocks are associated with the active block.

26. (New). The system, as set forth in claim 17, wherein the at least one other block is associated with a break point.

27. (New). The system, as set forth in claim 17, wherein the display is adapted to form a debugging window for displaying the blocks and having a tool bar for controlling program flow.

28. (New). The system, as set forth in claim 27, wherein the tool bar includes a toggle labels button and the computer based controller responds to actuation of the button for switching between default labels and alternate labels displayed for the blocks.

29. (New). The system, as set forth in claim 27, wherein the tool bar includes a Select Active Block button and the computer based controller responds to actuation of the button for displaying a currently active one of the blocks.

30. (New). The system, as set forth in claim 17, wherein the computer based controller includes means for adding a break point associated with a flowchart block and wherein the computer based controller being adapted to stop at the break point during the debugging mode.

31. (New). A method of machine programming and control, comprising the steps of:
editing and generating a continuous multi-block flow chart via a computer based controller, the flow chart representing a program for controlling the operations of a machine connected to the computer based controller;

operating the machine in accordance with the flowchart; and,

displaying a plurality of blocks associated with the flowchart on a display, wherein a first set of the blocks are displayed in a first color and a second set of the blocks are displayed in a second color.

32. (New). The method, as set forth in claim 31, wherein the at least one other block corresponds to an active block during a runtime execution.

33. (New). The method, as set forth in claim 32, wherein the at least one other block includes blocks associated with the active block.

34. (New). The method, as set forth in claim 31, wherein the at least one other block corresponds to an active block during a debugging process.

35. (New). The method, as set forth in claim 32, wherein the at least one other block includes blocks associated with the active block.

36. (New). The method, as set forth in claim 31, wherein the at least one other block corresponds to blocks that have been modified during an editing process.

37. (New). The method, as set forth in claim 32, wherein a third set of blocks are displayed in a third color.

38. (New). The method, as set forth in claim 37, wherein the third set of blocks are dependent upon the active block.

39. (New). The method, as set forth in claim 37, wherein the third set of blocks are associated with the active block.

Respectfully submitted,

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